

**Work Order ID 61903**

Thursday, September 09, 2010 1:13:20 PM

Page 1

Item ID: D350-588-011

Accept

Revision ID:

Item Name: Aft Door Fwd Hinge Modification

Start Date: 9/9/2010 Start Qty: 3.00

Required Date: 9/17/2010 , Req'd Qty: 3.00

Reference:

Approvals: Process Plan: *H*Date: *10-9-09* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
N/A	Rev N/A

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D350-588-011 CHG002

*Solidolay**10/10/09 BG 10-10-01*

110

0.00



Packaging

Packaging

Pick Kit

Memo

0.00

*10/10/09 (30)*

120

0.00



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

*Solidolay**(x3)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 61903**

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Item ID: D350-588-011

Accept

Setup Start

Revision ID:

Stop

Item Name: Aft Door Fwd Hinge Modification

Start Date: 9/9/2010 Start Qty: 3.00

Cust Item ID:

Required Date: 9/17/2010 Req'd Qty: 3.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-588-011

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

*10/10/10 5(3)*

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

*10/10/05**10/10/05*

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Page 1

Work Order ID: 61903

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 9/9/2010

Required Date: 9/17/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:M04.08.31 Added D2690-17 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN526C1032R7 Screw		Purchased	No			120	Each	60.0000	2	6		10/10/458	
-----------------------	--	-----------	----	--	--	-----	------	---------	---	---	--	-----------	--

Location	Loc Qty	Loc Code
ST328	60	
113064	9	
113749	1	
114056	50	

AN526C832R8 Screw		Purchased	No			120	Each	188.0000	8	24		10/10/458	
----------------------	--	-----------	----	--	--	-----	------	----------	---	----	--	-----------	--

Location	Loc Qty	Loc Code
ST327	188	
114615	88	
114718	100	

AN526C832R9 Screw		Purchased	No			120	Each	216.0000	8	24		10/10/2158	34
----------------------	--	-----------	----	--	--	-----	------	----------	---	----	--	------------	----

Location	Loc Qty	Loc Code
ST327	216	
114341	16	
115422	200	

W/O:		WORK ORDER CHANGES					
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Start Date: 9/9/2010

Required Date: 9/17/2010

Start Qty: 3.00

Required Qty: 3.00

AN960JD10 NAS1149D0363J Purchased No

120

Each

16.0000

4 12



Washer



M115622 10/10/4SP

## Location

## Loc Qty

## Loc Code

ST 6

107715 6

ST335 10

105792 10

AN960JD8 NAS1149DN832 Purchased No

120

Each

10.0000

24 72



Washer



M115832 10/10/4SP

## Location

## Loc Qty

## Loc Code

ST347 10

105059 10

D2143 Manufactured No

120

Each

17.0000

1



Hinge Bracket



3 10/10/4SP

## Location

## Loc Qty

## Loc Code

ST198 17

55323 17

D2144 Manufactured No

120

Each

42.0000

1



Hinge Bracket



3 10/10/4SP

## Location

## Loc Qty

## Loc Code

ST198 42

55179 42

3

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Page 2

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 9/9/2010

Required Date: 9/17/2010

Start Qty: 3.00

Required Qty: 3.00

S B D2150  
Packer Doubler, Hinge

Manufactured No

120 Each

34.0000

2 6



10/10/45

Location

Loc Qty

Loc Code

ST007

34

55178

34

S B D2151  
Packer Doubler, Hinge

Manufactured No

120 Each

19.0000



2 6

10/10/45

Location

Loc Qty

Loc Code

ST007

19

55319

19

S B D2153  
Door Prop

Manufactured No

120 Each

29.0000



1 3

10/10/45

Location

Loc Qty

Loc Code

ST272

29

59818

29

S B D2154  
Stud Bracket

Manufactured No

120 Each

10.0000



1 3

10/10/45

Location

Loc Qty

Loc Code

ST007

10

55325

10

S B D2237  
Striker Plate

Manufactured No

120 Each

41.0000



2 6

10/10/45

Location

Loc Qty

Loc Code

ST009

41

58181

19

60492

22

3 3

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 61903

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 9/9/2010

Required Date: 9/17/2010

Start Qty: 3.00

Required Qty: 3.00

D2461

Manufactured No

120 f

197.9772 7.25

22.89474



Neoprene "D" Seal

## Location

## Loc Qty

## Loc Code

ST402

197.9772105

39782

6.5

55054

191.477211

cut 1 X 87.00"

D2463

Manufactured No

120 f

183.6348 7.25

22.89474



Seal

## Location

## Loc Qty

## Loc Code

ST404

183.6348105

43841

3

50075

11.3536

55561

169.281211

cut 1 X 87.00"

D2583

Manufactured No

120 Each

18.0000



Latch Bracket

## Location

## Loc Qty

## Loc Code

ST017

16

60497

16

ST018

2

56527

2

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 61903

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 9/9/2010

Required Date: 9/17/2010

Start Qty: 3.00

Required Qty: 3.00

D2585  
Mounting Channel

Manufactured No

120 Each

55.0000

2

16  
col/d 24 sl

Location

Loc Qty

Loc Code

ST019

55

56524

1

59118

28

59873

26

D2586  
Door Latch

Manufactured No

120 Each

38.0000

2

6  
col/d 24 sl

Location

Loc Qty

Loc Code

ST006

38

57917

38

D2587  
Door Slug, 350 Hinge

Manufactured No

120 Each

24.0000

1

6  
3  
col/d 24 sl

Location

Loc Qty

Loc Code

ST019

24

56555

24

D2589  
Keys, Key Chain, 350 Hinge

Manufactured No

120 Each

185.0000

1

3  
col/d 24 sl

Location

Loc Qty

Loc Code

ST019

185

58194

185

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 6

Work Order ID: 61903

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 9/9/2010

Required Date: 9/17/2010

Start Qty: 3.00

Required Qty: 3.00

D2690-17

Manufactured No

120

Each

3.0000



Cable



1 3  
10/10/4 SP

## Location

## Loc Qty

## Loc Code

ST021

3

58212

3

D2857-1

Manufactured No

120

Each

37.0000



Hinge Bracket



3  
1 3  
B61525 10/10/4 SP

## Location

## Loc Qty

## Loc Code

ST026

37

56529

14

57924

23

D2857-2

Manufactured No

120

Each

42.0000



Hinge Bracket



1 3  
B61529 10/4/8 SP

## Location

## Loc Qty

## Loc Code

ST027

42

55020

4

56530

14

57925

24

D2858-1

Manufactured No

120

Each

16.0000



Hinge Bracket



1 3  
10/10/4 SP

## Location

## Loc Qty

## Loc Code

ST027

16

56423

16

3

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Thursday, September 09, 2010 1:13:26 PM

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Work Order ID: 61903

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 9/9/2010

Required Date: 9/17/2010

Start Qty: 3.00

Required Qty: 3.00

D2858-2 Manufactured No 120 Each 8.0000 1



Hinge Bracket



3  
10/10/14 SP

## Location

## Loc Qty

## Loc Code

ST027

8

56048

8

3

FG-778150-550-ROL

Purchased No



7781 9oz Glass 50"x125yd

120 sf

2,030.750

1



3  
10/10/14 SP

## Location

## Loc Qty

## Loc Code

ST404

2030.75

108932

18

111166

402

113905

1610.75

3x

1-cut 1 square ft of glass cloth

MS20426AD3-4

Purchased No



RIVET

120 Each

6,540.000

12



36  
10/10/14 SP

## Location

## Loc Qty

## Loc Code

ST316

6540

104374

2540

110398

4000

MS20470AD4-5

Purchased No



Rivet, Universal Head

120 Each

1,077.000

18



54  
10/10/14 SP

## Location

## Loc Qty

## Loc Code

ST309

1012

114761

1012

ST319

65

111916

65

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Page 7

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Work Order ID: 61903

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 9/9/2010

Required Date: 9/17/2010

Start Qty: 3.00

Required Qty: 3.00

MS21042L08

Purchased

No

120

Each

362.0000

18

54



10/10/4sf

S  
B Nut

## Location

## Loc Qty

## Loc Code

ST300

362

105430

10

115016

52

115300

200

115594

100

54

MS21042L3

Purchased

No

120

Each

2,081.000

4

12



10/10/4sf

S  
B Nut

## Location

## Loc Qty

## Loc Code

ST300

2081

104625

10

114523

109

114784

1962

12

MS27039-08-11

Purchased

No

120

Each

65.0000

2

6



10/10/4sf

S  
B Screw

## Location

## Loc Qty

## Loc Code

ST288

50

114382

50

ST290

15

113749

15

6

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Work Order ID: 61903

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Parent Item Name: Aft Door Fwd Hinge Modification



Start Date: 9/9/2010

Required Date: 9/17/2010

Start Qty: 3.00

Required Qty: 3.00

MS27039-1-15

Purchased

No

120

Each

85.0000

2 6



Screw



10/10/10 sl (30)

Location

Loc Qty

Loc Code

ST292

85

114056

2

114718

83

6

W/O:		WORK ORDER CHANGES					
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## 52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

\* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

## 52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X	X	D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	1/2" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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52-00-00